

Work Order ID 55457

January 19, 2010 9:26:38 AM

Page 1

Item ID: D3791-1

Accept

Revision ID:

Item Name: Wearplate

Start Date: 1/19/10 Start Qty: 12.00

Required Date: 1/25/10 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan: *RA*

Date: *10-1-19*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3791

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3791

Dwg Rev: *A*

Prog Rev: *A*

304 - 063

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-1-25

(12)

B 10-1-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 8 10/01/25

0.00

412

QC

Memo

Quality Control

130

NC BRAKE

0.00

0.00

SB 10/01/28

12

Brake NC

Memo

Brake NC

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

140

QC5- Inspect part completeness to step on W/O

0.00

0.00

⇒ 5 10/01/28

412

QC

Memo

Quality Control

Ensure joggle as per dwg D3429

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Item ID: D3791-1

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 1/19/10 Start Qty: 12.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Large Fab

Large Fab

0.00

Large Fab

Memo

0.00

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M113521*EL**10-2-1**(X12)*

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

*2) Sidelori**(X12)*

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*2) Sidelori**(X12)**φ*

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

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Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

112588

0.00

0.00

⇒ W

10/02/10

(X12)

Ø

Memo

START TIME: 1:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 1:30pm

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

BR 10-02-11

(12)

Memo

200



Packaging

Packaging

Identify as per dwg & Stock Location: FR-19

0.00

0.00

W 10/02/11

(X12)

Ø

Memo

W/O:		WORK ORDER CHANGES					
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Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/11 *[Signature]*

UMF 10-2-11

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

January 19, 2010 9:26:42 AM

Page 1

Work Order ID: 55457



Parent Item: D3791-1

Parent Item Name: Wearplate

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	260.9779	3.6846			



304/316 Sheet .063



1310-1-25

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT

260.9778737

106860

8.0295

111924

25.1689737

112442

29.8899

113295

197.8895

1385

12

W/O:		WORK ORDER CHANGES					
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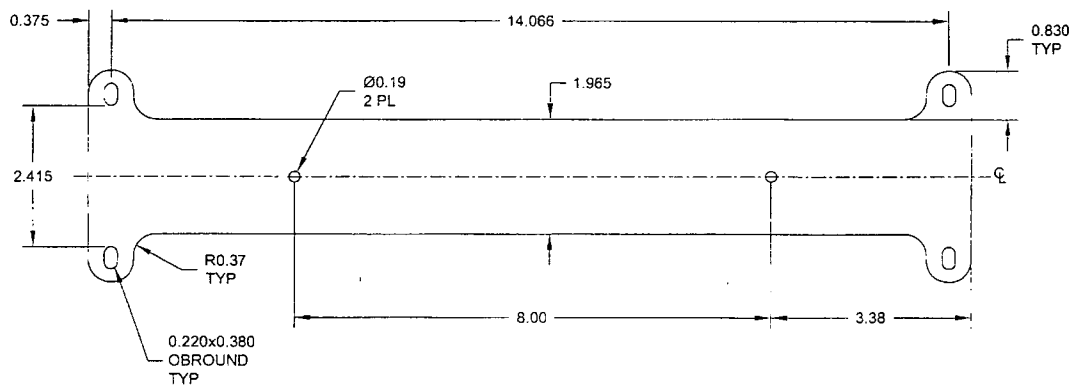
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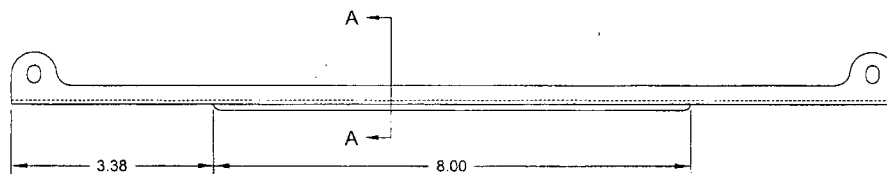
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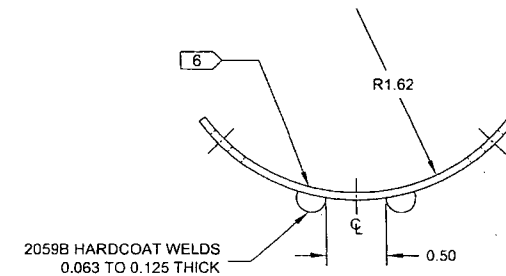
NOTE: Date & initial all entries



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
 (MAKE FROM D3791-1F)



SECTION A-A
 SCALE 2X

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 55457
BT 10-1-19

RELEASED
 08-05-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A NEW ISSUE		PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.13		

DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWING NO. D3791	REV. A SHEET 1 OF 1
TITLE WEARPLATE	SCALE NTS
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